

Work Order ID 159138***159138***

Page 1

Wednesday, April 05, 2017 8:56:22 AM

Item ID: D4811-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pin, Quick Release
Start Date: 4/6/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 4/12/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: **DAS 13 9-89** Date: **APR 05 2017** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4811	A								

100 PURCHASING 0.00 **DAS 13 9-89**

100

Purchasing

Purchasing

Memo

Issue P/O: **35878**Possible Supplier: McMaster Carr
Supplier p/n: 98470A133

Material release note is required

110

110

Packaging

Packaging

Memo

Ensure Material Release Note is attached

10x SP 17-4-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00				10			DAS 38 9-89 APR 11 2017
Quality Control									
130	Identify as per dwg & Stock Location: 81GA	0.00							
130									
Packaging	Memo	0.10				10x			DAS 26 9-89 APR 12 2017
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	1.00							17/4/1388
Quality Control									DAS 21 9-89 APR 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, April 05, 2017 8:56:22 AM

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Work Order ID: 159138

159138

Parent Item: D4811-1

D4811-1

Parent Item Name: Pin, Quick Release

Start Date: 4/6/2017

Required Date: 4/12/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 13.05.21 AS PER DWG REV.A VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
98470A133		Purchased	No			110	Each	0.0000	1	10			
98470A133									**				
Pin, Quick Release													

10x 8017-4-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

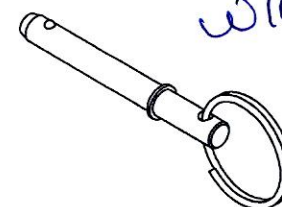
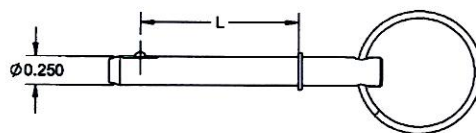
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

SPECIFICATION CONTROL DRAWING

DAS
13
9-83

APR 05 2017

W10: 1 59138



DART PART NUMBER	DESCRIPTION	POSSIBLE VENDOR	VENDOR PART NUMBER	L	MATERIAL
D4811-1	QUICK RELEASE PIN	MCMaster CARR	98470A133	1.347	18-8 SS

RELEASED
2013-05-16

NOTES:

- 1) MATERIAL: PER TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 METHOD 6.7
- 7) WEIGHT: N/A

A	NEW ISSUE	DB	13.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	DB		
CHECKED	A.P.		
MFG. APPR.	11		
APPROVED	11		
DE APPR.	11		
DATE	13.04.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4811

REV. A
SHEET 1 OF 1

TITLE
QUICK RELEASE PIN

SCALE
NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35878**

Purchase Order Date 4/6/2017

PO Print Date 4/6/2017

Page Number 3 of 5

Order From :
MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via: Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 10

Currency USD

FOB FCA - (Free Carrier)

6	98470A133	Pin, Quick Release	4/10/2017 Yes 4/10/2017	10.00 Each	\$3.01	\$30.10
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AS PER DWG D4811 REV. A
B159138

DAS
38
9-89

SP174-11
Line Total: \$30.10

7	71500-15	29045A777 #52 JOBBER DRILL	4/10/2017 Yes 4/10/2017	3.00 Each	\$2.60	\$7.80
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Line Total: \$7.80

Deliver To: CARL

8	71500-40	91251A353 10/32 HEX BOLT	4/10/2017 Yes 4/10/2017	6.00 Each	\$4.64	\$27.84
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Line Total: \$27.84

Deliver To: GARY

Note:

4/6/2017



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO35878

Order Placed By
Chantal Lavoie

McMaster-Carr Number
1560781-02

Page 1 of 1

04/06/2017

Line	Product	Ordered	Shipped
2	6605K56 Hook and Loop Cable Ties 24" Overall Length, Meets UL 94V2, Packs of 5	3 Packs	3
3	95606A170 Nylon Plastic Washer for 7/16" Screw Size, 0.5" ID, 0.688" OD, Off-White, Packs of 100	1 Pack	1
4	30365T35 Eye-to-Clevis Swivel - Not for Lifting 316 Stainless Steel, 5-3/4" Long	4 Each	4
5	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End 3/8"-24 RH Male Shank, 3/8" Ball ID, 1-1/4" Long Thread	10 Each	10
6	98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin Ring Grip, 1/4" Diameter, 1.3" Usable Length	10 Each	10
7	29045A777 Long-Life TiN-Coated High-Speed Steel Jobbers' Drill Bit Wire Gauge 52, 1-7/8" Overall Length, 0.8" Drill Depth, 135Deg Point	3 Each	3
8	91251A353 Black-Oxide Alloy Steel Socket Head Screw 10-32 Thread Size, 2" Long, Partially Threaded, Packs of 25	6 Packs	6
9	6713A22 220 Grit Stone Set for 11/16" - 2-1/2" ID Flexible Precision-Finish Cylinder Hone	1 Each	1
10	3099K42 Digital Food and Beverage Pocket Thermometer	1 Each	1
11	7509A82 Gasketing Adhesive 3M 1300L, 32 oz. Can	3 Each	3
12	1372N35 Multipurpose Neoprene Rubber Strip with Certificate, 2" x 36", 1/8" Thick, 50A Durometer	15 Each	4

Shipped separately from our Chicago warehouse on 04/06

1	86715K27 High-Strength Oil-Resistant Buna-N Rubber Sheet Adhesive Back, 1/16" Thick, 12" X12", 60A Durometer	4 Each	4
12	1372N35 Multipurpose Neoprene Rubber Strip with Certificate, 2" x 36", 1/8" Thick, 50A Durometer	15 Each	11

Notes about your shipment

The U.S. Department of Transportation regulates the shipping of lines 10 and 11. By purchasing from McMaster-Carr Supply Company, you agree not to transport or permit others to transport purchased items except in accordance with U.S. law and any other applicable laws.